







Work Order ID 52276




Tuesday, September 22, 2009 1:17:31 PM

Page 2

Item ID: D3350-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Strut Assembly
Start Date: 9/23/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 10/2/2009 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SA 09/09/27			6	0		
140  Small Fab Small Fab	Small Fab Memo Tumble and Deburr	0.00 0.00	SA 09/09/27						
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	M 09/09/30			(X6)	0		




Work Order ID 52276

Tuesday, September 22, 2009 1:17:31 PM

Page 3

Item ID: D3350-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Strut Assembly
Start Date: 9/23/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 10/2/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>9/30/09/01</u> (6)
170  Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3350. Identify as D3350-041 and batch number using a fine point permanent marker	0.00 0.00							<u>9/30/09/10/27</u> (6)
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>2/8 02/10/22</u> (6) \$

Work Order ID 52276

Tuesday, September 22, 2009 1:17:31 PM



Page 4

Item ID:	D3350-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Strut Assembly					
Start Date:	9/23/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	10/2/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M1112148</i> Memo START TIME: <i>9:00am</i> OVEN TEMPERATURE: <i>9:30am</i> FINISH TIME: <i>320°F</i>	0.00 <i>7 M 09/10/08</i> 0.00				<i>(X6) 0</i>			
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>X6</i>			
210 Packaging Packaging	Identify as per dwg & Stock Location: <i>271</i> Memo	0.00 0.00				<i>9/10/08</i>			<i>(Signature)</i>

Work Order ID 52276

Tuesday, September 22, 2009 1:17:31 PM

Page 5

Item ID: D3350-041

Accept

Revision ID: A

Item Name: Strut Assembly

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/2/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/28
RL 09-10-25

Picklist Print

Page 1

Tuesday, September 22, 2009 1:17:31 PM

Work Order ID: 52276

Parent Item: D3350-041RevA

Parent Item Name: Strut Assembly

Comments:


Start Date: 9/23/2009

Required Date: 10/2/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3		Purchased	No			110	Each	3,663.000	12.0000			
												
Nut												

Warehouse Loc Qty Loc Code


Location

Main Warehouse

ST	3663	
110844	32	
111274	139	
111668	992	
112314	2000	
112385	500	

EP 09/10/01

12

AN3-12A		Purchased	No			170	Each	139.0000	12.0000			
												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	139	
106605	23	
109297	16	
112720	100	

EP 09/10/01

12

Picklist Print

Page 2

Tuesday, September 22, 2009 1:17:31 PM

Work Order ID: 52276



Parent Item: D3350-041RevA



Parent Item Name: Strut Assembly

Start Date: 9/23/2009

Required Date: 10/2/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 		Purchased	No			170	Each	2,117.000	24.0000			
Washer												

9/30/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2117

105442

95

109059

2

109840

23

110985

202

111279

5

111668

64

112314

1000

112369

726

24

D2324-5RevC

Manufactured

No

170

Each

11.0000

12.0000



Strap

9/30/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

46324

1

47563

10

11

352661

(K)

Tuesday, September 22, 2009 1:17:31 PM

Shop Packet Print

Page 2

Picklist Print

Page 3

Tuesday, September 22, 2009 1:17:31 PM

Work Order ID: 52276



Parent Item: D3350-041RevA



Parent Item Name: Strut Assembly

Start Date: 9/23/2009

Required Date: 10/2/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X00.75 0		Purchased	No			170	f	45.8353	7.9604			



6061-T6 Bar .750 x .750

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

45.8353

107387

2.49

108877

3.3453

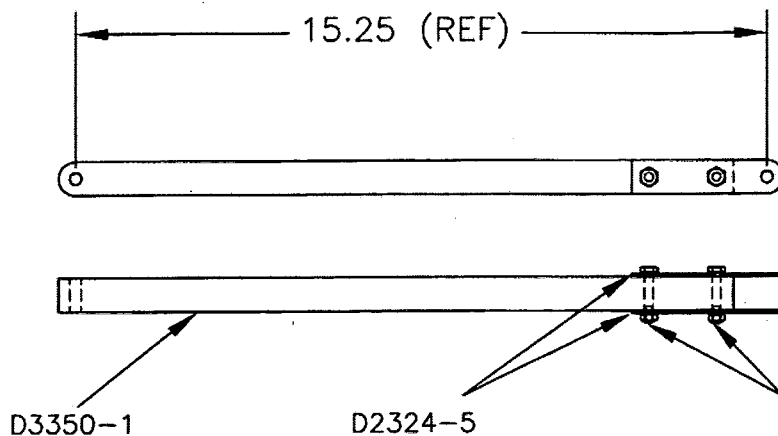
112567

40

7.9604 DSA 09/09/24

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	

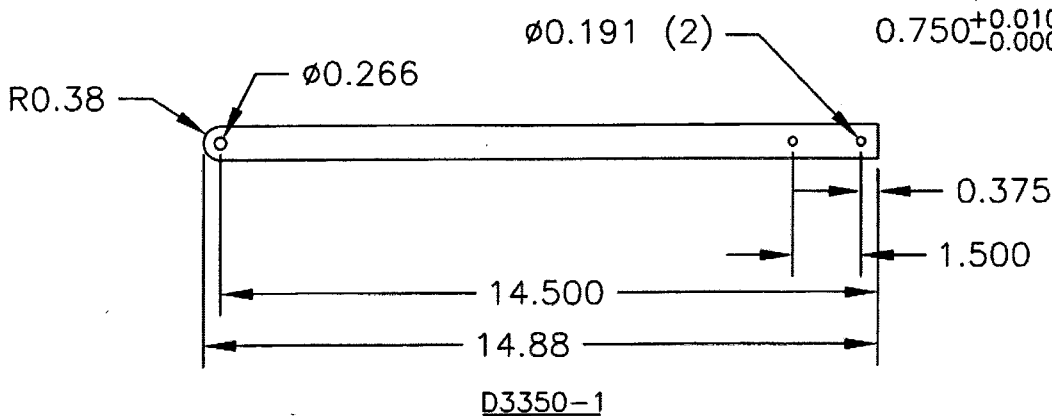


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52776

AN3-12A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(TYP 2 PLACES)

D3350-041 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



RELEASED

04.12.16

D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.